

June-09-14 2:42:01 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

60

Cust Item ID:

60

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Draw Nbr	Revision Nbr	
D4379	C	

100 0.00 DAS

Doosan

Doosan Lathe

Memo

turn as per Dwg and folio FB300

Dwg Rev: C

FOLIO REV: AA

Deburr

110

QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

DAS
40
9-89

14/06/11

DAS
40
9-83

14/06/11

Work Order ID 120647

120647

Page 2

June-09-14 2:42:01 PM

Item ID: D4379-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Cup

Start Date: 6/09/14

Start Qty: 60.00

60

Cust Item ID:

Required Date: 6/20/14

Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

JB
14/6/12

120

QC

Memo

0.00

Quality Control

(65)
count

14-6-12

130

Identify as per dwg & Stock Location: W4001

0.00

130

Packaging

Memo

0.00

Packaging

65x
DAS
28
9-89

JUN 12 2014

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 14-06-12

MLJ 14-06-12

Picklist Print

June-09-14 2:41:58 PM

Page 1

Work Order ID: 120647

120647

Parent Item: D4379-5

D4379-5

Parent Item Name: Wearplate Cup

Start Date: 6/09/14

Required Date: 6/20/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A NEW ISSUE 14-04-01 JLM VERIFIEWD BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R1.000		Purchased	No				f	58.8400		3			
------------	--	-----------	----	--	--	--	---	---------	--	---	--	--	--

M304R1 000

304 round bar 1.00

M/06/14

**DAS
40
9-88**

Location

Loc Qty

Loc Code

MAT012

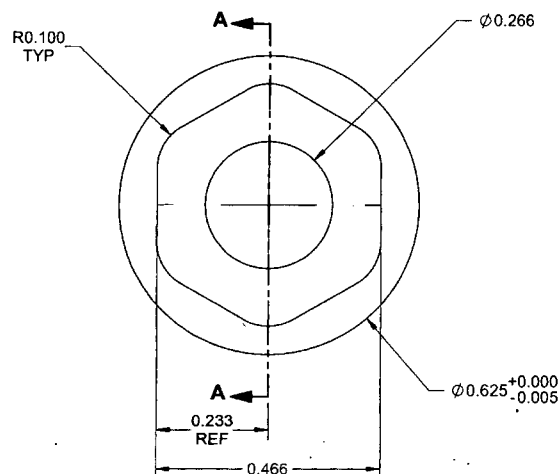
58.84



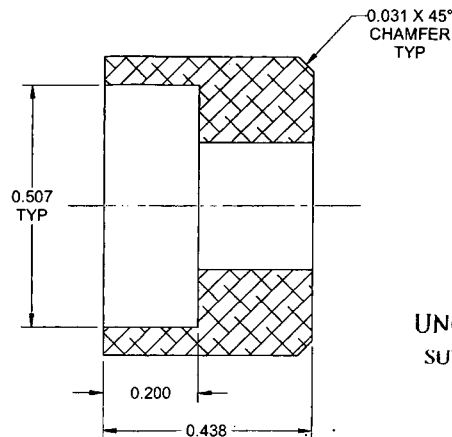
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58.84

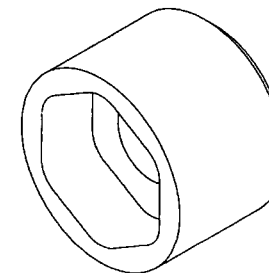
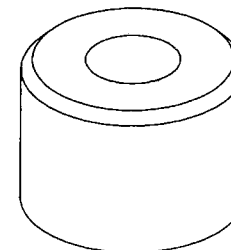
3,840



D4379-1 WEARPLATE CUP



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120647 MJS

1406-09

RELEASED

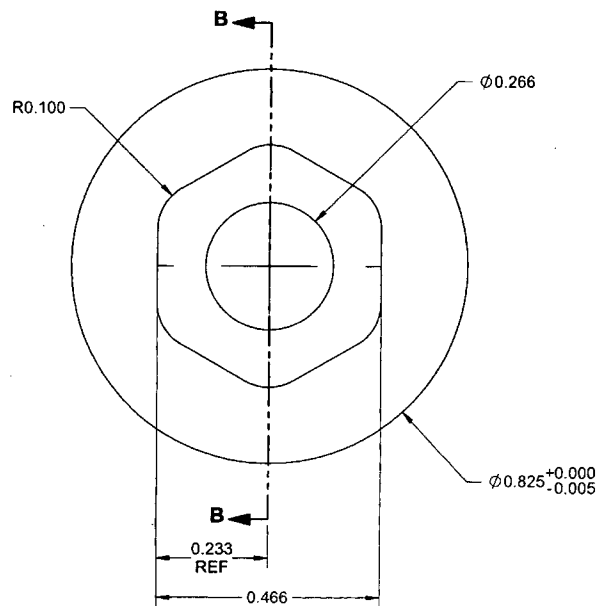
2014 MAR 29. *CP*
ECN 14-544

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.02 lbs

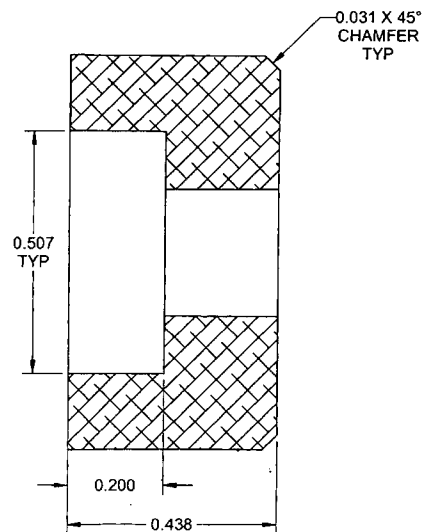
C	ADD D4379-5 WEARPLATE CUP	DB	14.03.19
B	ADD D4379-3 WEARPLATE CUP	AP	12.07.04
A	NEW ISSUE	AJS	11.03.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D4379	
MFG. APPR.	DD	REV. C	
APPROVED	MP	TITLE WEARPLATE CUP	
DE APPR.	DS	SCALE NTS	
DATE	14.03.19	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

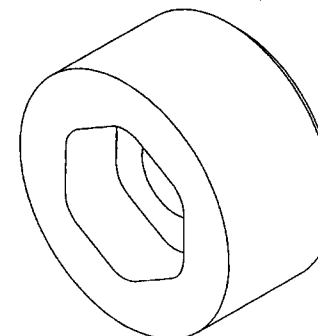
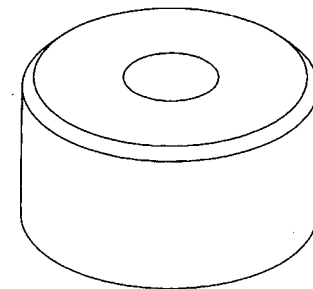
SHEET 1 OF 3



D4379-3 WEARPLATE CUP



SECTION B-B



RELEASED

2014 MAR 29

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

APPROVED	DESIGN	AJS	DART AEROSPACE LTD	
	DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. C
	MFG. APPR.	DD	D4379	SHEET 2 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	WEARPLATE CUP	NTS
DATE		14.03.19	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

C

B

A

$\phi 0.875^{+0.000}_{-0.005}$

C

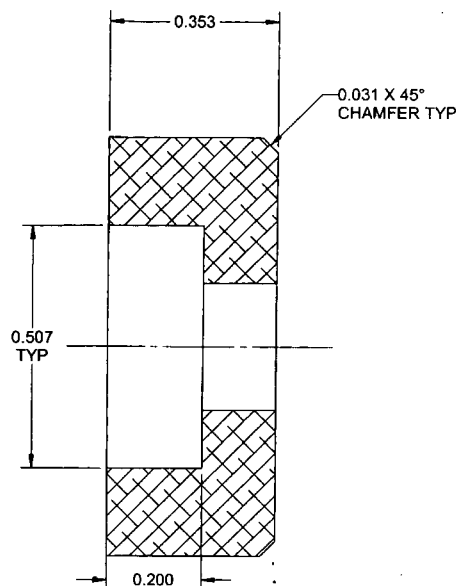
$\phi 0.266$

R0.100
TYP

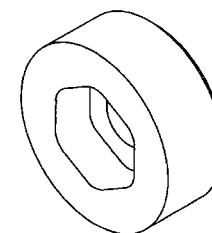
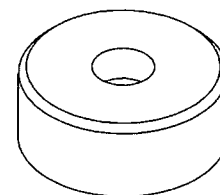
0.233
REF

0.466

D4379-5 WEARPLATE CUP



SECTION C-C



RELEASED

2014 MAR 29 *q*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR PER ASTM A276
REF. DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs

APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	DD	D4379	SHEET 3 OF 3
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPLATE CUP	NTS
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8 7 6 5 4 3 2 1